

Date: Friday, 17/08/2007 11:21:14 AM  
 User: Linda Lacelle

## Process Sheet

|                                  |                                       |                         |                        |
|----------------------------------|---------------------------------------|-------------------------|------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b>     | : BLOWER MOTOR SUPPORT |
| <b>Job Number</b>                | : 34083                               |                         |                        |
| <b>Estimate Number</b>           | : 12309                               |                         |                        |
| <b>P.O. Number</b>               | : N/A                                 | <b>Part Number</b>      | : D3471043             |
| <b>This Issue</b>                | : 17/08/2007                          | <b>S.O. No.</b>         | : N/A                  |
| <b>Prsht Rev.</b>                | : NC                                  | <b>Drawing Number</b>   | : D3471 REV.A          |
| <b>First Issue</b>               | : N/A                                 | <b>Project Number</b>   | : N/A                  |
| <b>Previous Run</b>              | : 28559                               | <b>Drawing Revision</b> | : A                    |
|                                  |                                       | <b>Material</b>         | : N/A                  |
| <b>Written By</b>                | : <i>[Signature]</i>                  | <b>Due Date</b>         | : 11/09/2007           |
| <b>Checked &amp; Approved By</b> | : <i>[Signature]</i>                  | <b>Qty:</b>             | 8                      |
| <b>Comment</b>                   | : est rev A 06.03.02 New issue EC     | <b>Um:</b>              | Each                   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |       |
|-----|-----------|-------|
| 1.0 | MS3584216 | CLAMP |
|-----|-----------|-------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 pick:

|     |             |             |                                   |
|-----|-------------|-------------|-----------------------------------|
| Qty | Part number | Description | Batch                             |
| 1   | MS35842-16  | CLAMP       | M10540825 / M10076123 FF 07-09-06 |

|     |            |       |
|-----|------------|-------|
| 2.0 | MS20427M44 | RIVET |
|-----|------------|-------|



**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)  
 pick:

|     |             |             |                                    |
|-----|-------------|-------------|------------------------------------|
| Qty | Part number | Description | Batch                              |
| 3   | MS20427M4-4 | Rivet       | M100393218 / M10540825 FF 07-09-06 |

|     |        |         |
|-----|--------|---------|
| 3.0 | D34713 | SUPPORT |
|-----|--------|---------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 pick:

|     |             |             |                      |
|-----|-------------|-------------|----------------------|
| Qty | Part number | Description | Batch                |
| 1   | D3471-3     | Support     | B9410327<br>B2612621 |

FF 07-09-06

|     |             |                               |
|-----|-------------|-------------------------------|
| 4.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

FF 07-09-10

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |  |                |                           |                       |                          |
|----------|------|---|-----------------------------|--|----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B |  |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng  | Sign &<br>Date |                           |                       |                          |
| 07/09/06 | 4    | 3 clamp shifted when<br>Transferring Hole. Hole<br>off centre. Hole is oval<br>as well.<br>R.C. Transfer drilling from<br>Aluminum to steel, causing the<br>drill bit to wander.<br>- tell employee to use <del>Tant</del><br>Transfer Punch. | QSIWZ                       | <del>Set up and reworked</del><br>(07/09/06) (07/09/06) (07/09/06) (07/09/06)<br>Replace 3X0 3471-3 B 26126K1<br>B 334103 XZ | 07/09/06<br>FF | En<br>07/09/10            | QSIWZ                 | 1070906                  |
|          |      |   |                             |  |                |                           |                       |                          |
|          |      |   |                             |  |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:14 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34083

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/08/10 (8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-09-10

8

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8)  
07/09/11

Job Completion



U 07-09-11

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

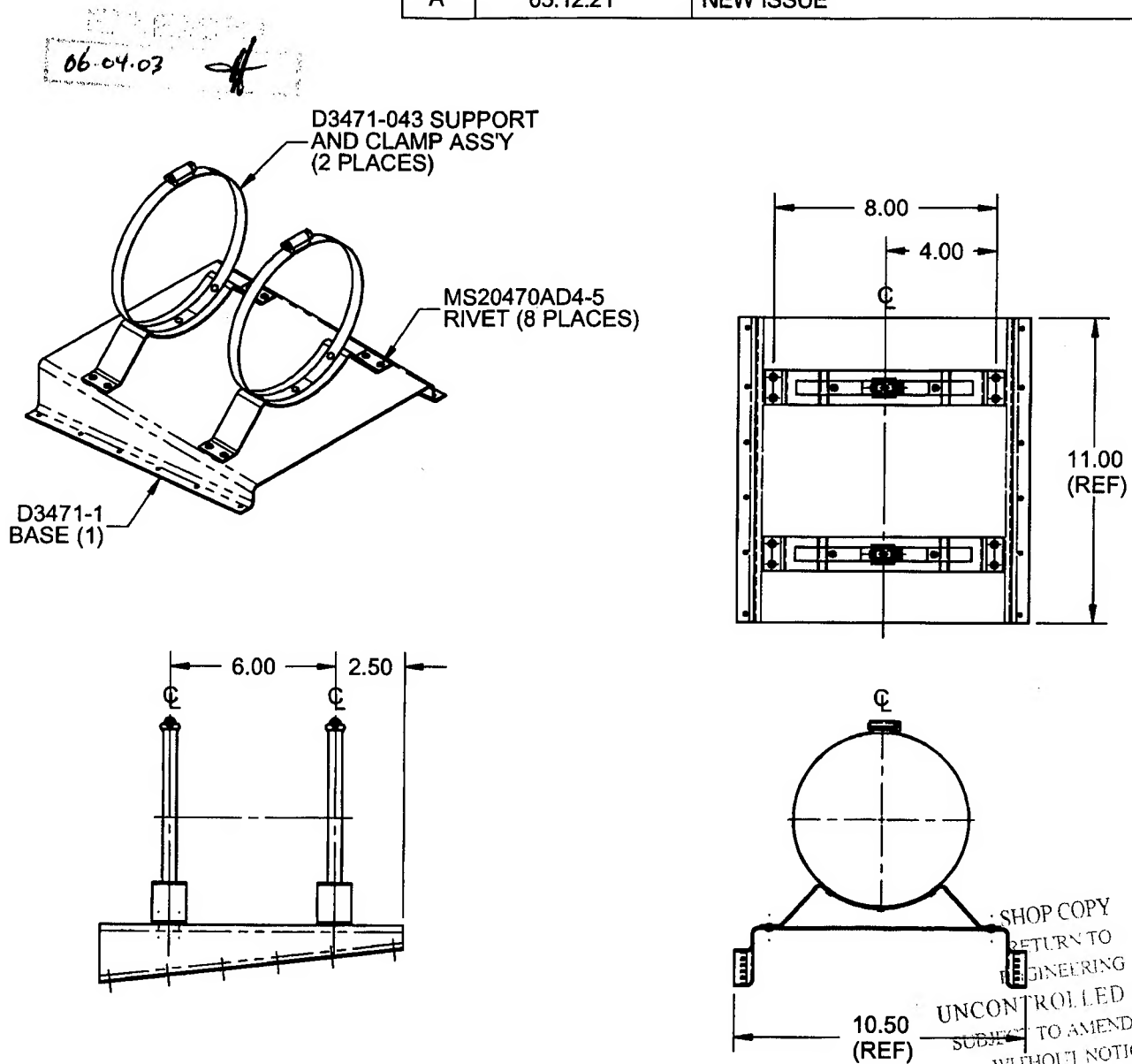
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                               |                                      |  |                        |
|-------------------------------|--------------------------------------|--|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i>       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>       | DRAWING NO.<br><b>D3471</b>                              | REV. A<br>SHEET 1 OF 5 |
| DATE<br><b>05.12.21</b>       | TITLE<br><b>BLOWER MOTOR SUPPORT</b> |  | SCALE<br>1:6           |
| A                             | 05.12.21                             | NEW ISSUE  |                        |

**D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY<br>-041 | P/N          | DESCRIPTION                |
|-------------|--------------|----------------------------|
| X           | D3471-041    | BLOWER MOTOR SUPPORT       |
| 2           | D3471-043    | SUPPORT AND CLAMP ASSEMBLY |
| 1           | D3471-1      | BASE                       |
| 8           | MS20470AD4-5 | RIVET                      |

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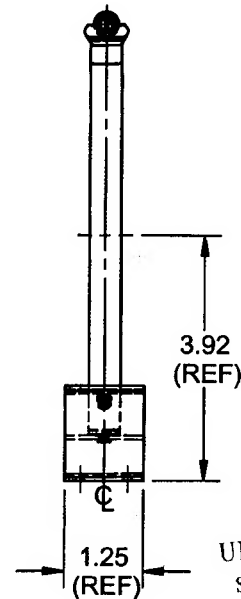
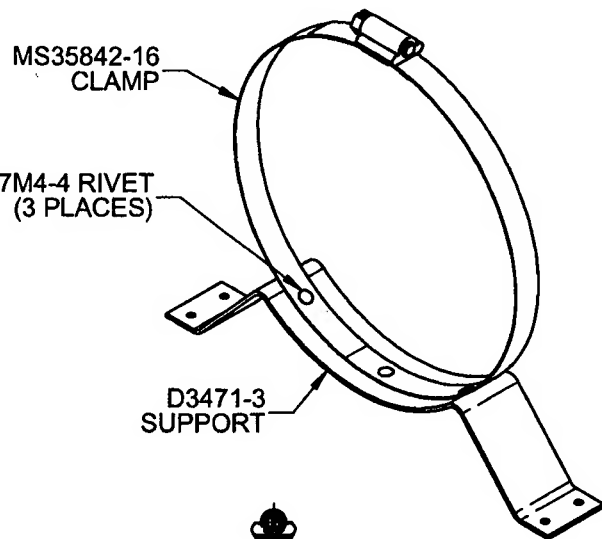
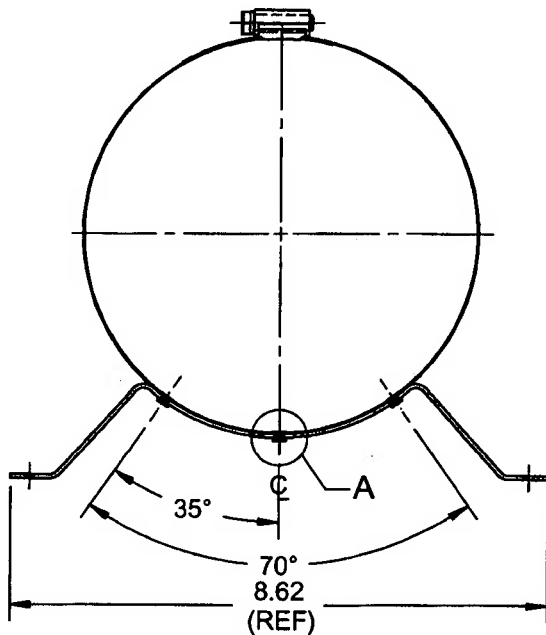
|                               |                                |   |                              |
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| DATE<br>05.12.21              |                                | TITLE<br>BLOWER MOTOR SUPPORT                     | SHEET 2 OF 5<br>SCALE<br>1:3 |

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL  
#30 ( $\phi 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\phi 0.230 \times 100^\circ$   
(3 PLACES)



**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1



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### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

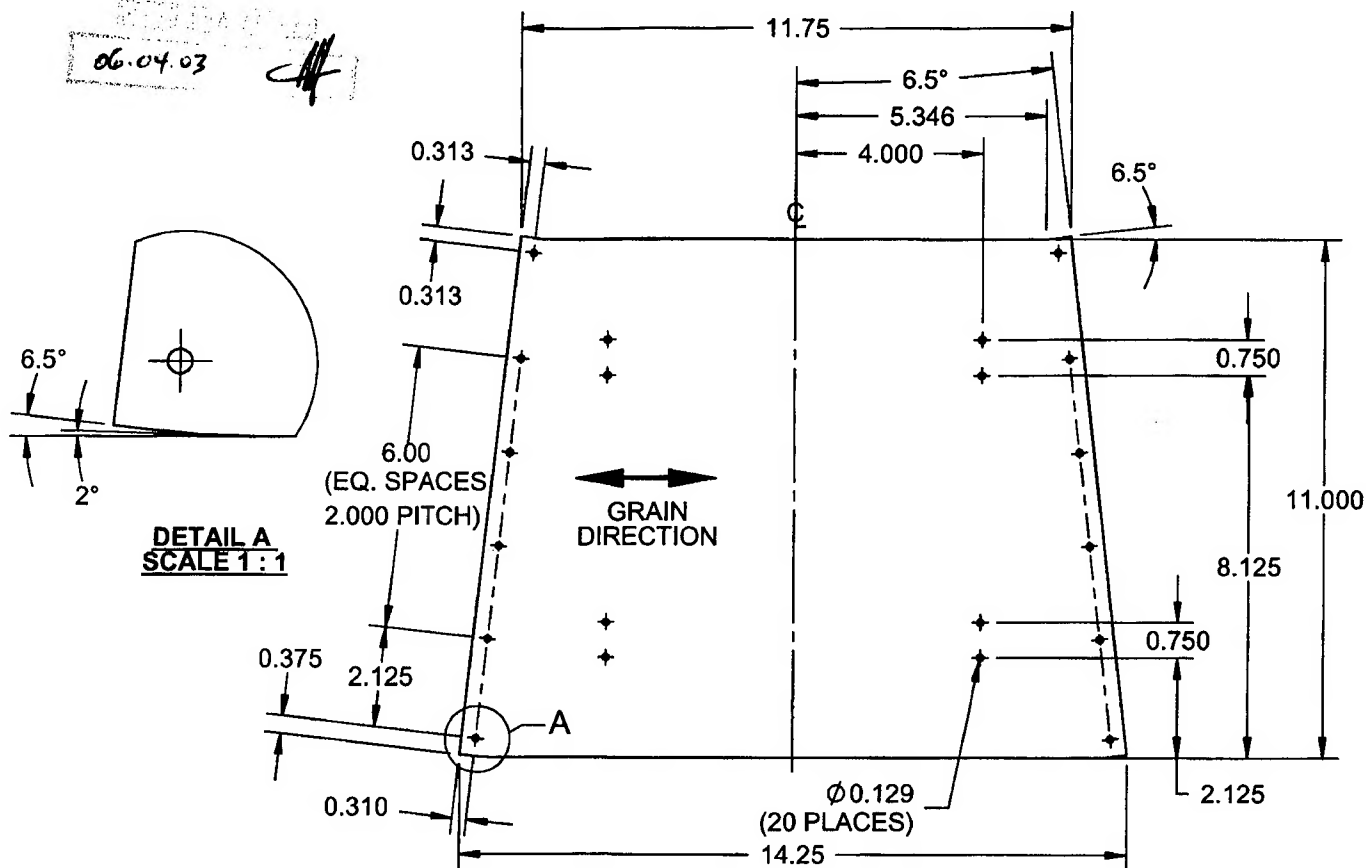
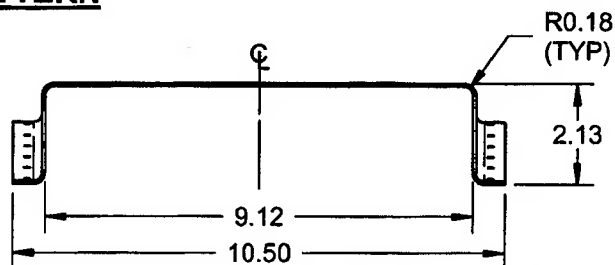
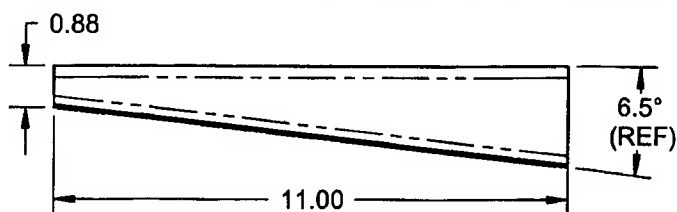
| QTY<br>-043 | P/N        | DESCRIPTION                |
|-------------|------------|----------------------------|
| X           | D3471-043  | SUPPORT AND CLAMP ASSEMBLY |
| 1           | D3471-3    | SUPPORT                    |
| 3           | MS20427M-4 | RIVET                      |
| 1           | MS35842-16 | CLAMP                      |

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| DATE<br><b>05.12.21</b>       |                                | TITLE<br><b>BLOWER MOTOR SUPPORT</b>                     | SCALE<br>1:4           |

**D3471-1F BASE FLAT PATTERN****D3471-1 BASE BENDING DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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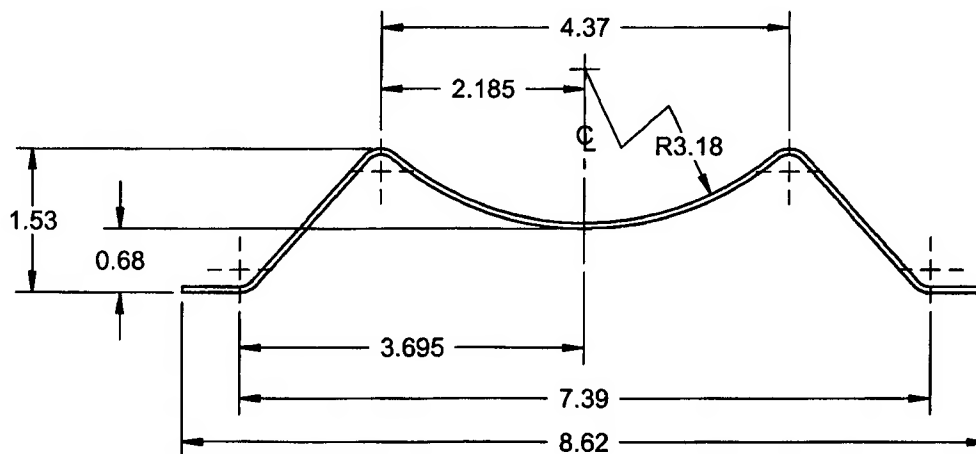
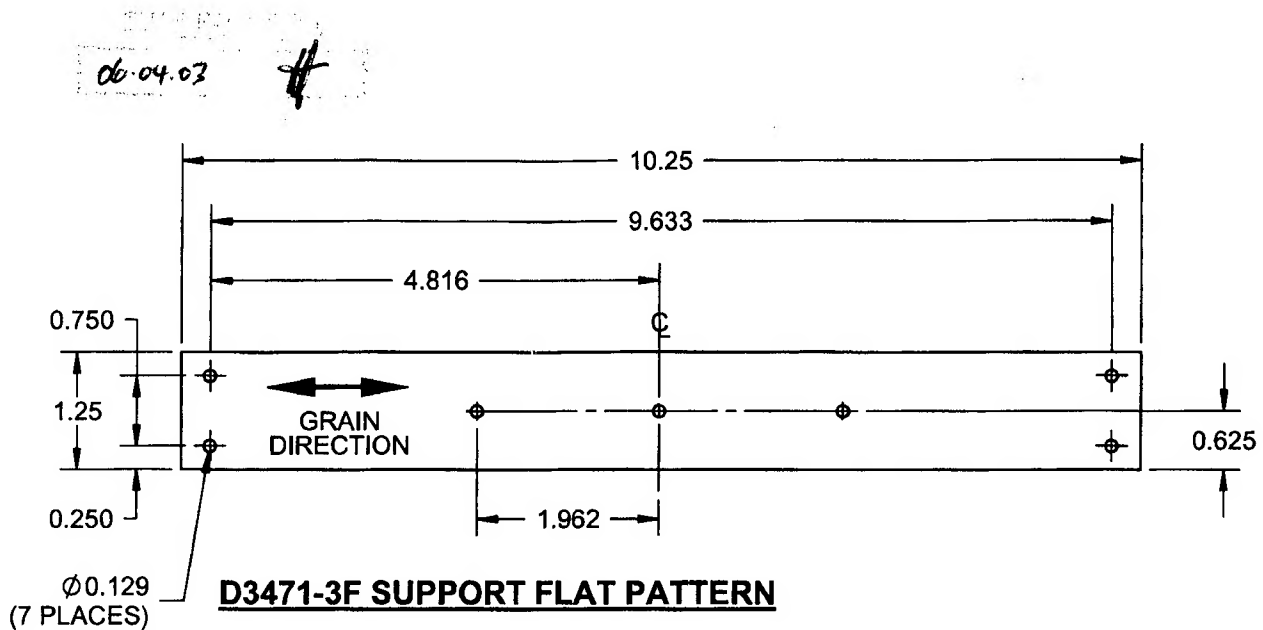
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| DATE<br><b>05.12.21</b>       |                                | TITLE<br><b>BLOWER MOTOR SUPPORT</b>                     | SHEET 4 OF 5<br>SCALE<br>1:2 |

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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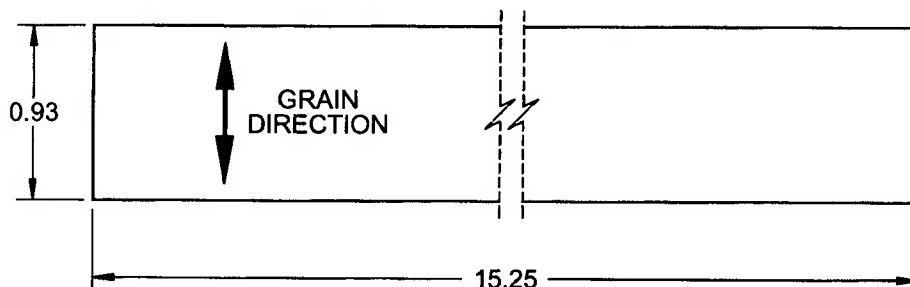
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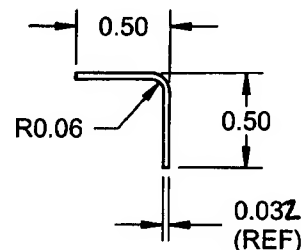


|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
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| DATE<br><b>05.12.21</b>       |                                | TITLE<br><b>BLOWER MOTOR SUPPORT</b>                     | SCALE<br>1:1           |

06.04.03 *[Signature]*



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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